

Date: Monday, 9/10/2007 1:27:49 PM  
 User: Kim Johnston

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: 206/OH-58 SADDLE, OUTBOARD, LEFT SIDE	
Job Number	: 34486				
Estimate Number	: 12924				
P.O. Number	: N/A		Part Number	: D29321UP	
This Issue	: 9/10/2007 S.O. No. : N/A		Drawing Number	: D2932 REV C	
Prsht Rev.	: NC		Project Number	: N/A	
First Issue	: N/A		Drawing Revision	: C	
Previous Run	: N/A		Material	: N/A	
Written By			Due Date	: 9/30/2007	
Checked & Approved By			Qty:		
Comment	: Est Rev.A		8 Um.	Each	
99/1					

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :		
1.0	D6101003	7075-T7351 2X6.25X7.875		
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s) 7075-T7351 2X6.25X7.875 Issue material from stock: 7075-T7351 Cut Size 2.0 x 6.25 X 7.880 Grain Along Long 7.88 Length Batch No: 534406		SP100 34/60 BG 02-09-18 (8)
2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1		
		Comment: HAAS CNC VERTICAL MACHINING #1 Program part number and batch number. 1-Inspect part number and batch number are programmed correctly. 2-Machine Step No 1 of Folio and visually inspect as per dwg D2932 & attached Dimension Sheet 3-Machine Step No 2 of Folio and visually inspect as per dwg D2932 & attached Dimension Sheet 4-Machine Step No 3 of Folio and visually inspect as per dwg D2932 & attached Dimension Sheet 5-Deburr & TUMBLE		BG / 8/02/09/19
3.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE		
		Comment: CONVENTIONAL MILLING MACHINE Machine Keyway and inspect per attached dimension sheet		TEG / 8.8 02/09/19
4.0	QC1	INSPECT ALL DIM TO DIM SHEET		
		Comment: INSPECT ALL DIM TO DIM SHEET		BG / 8.8 02/09/19

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes  No  DQA:  Date: 07108121  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 9/10/2007 1:27:49 PM  
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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206/OH-58 SADDLE, OUTBOARD, LEFT SIDE

Job Number: 34486

Part Number: D29321UP

Job Number:



Seq. #: Machine Or Operation:

Description :

5.0 QC8 SECOND CHECK



Comment: SECOND CHECK

JL 07-09-20

6.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



(9)

Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

BL 07-09-20

7.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

Co 07/15/21 (9)

8.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

sty 74

07/15/21 (9)

9.0 QC21 FINAL INSPECTION/W/O RELEASE



(9)

Comment: FINAL INSPECTION/W/O RELEASE

BL 07-09-20

Job Completion



BL 07-09-21

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD				Work Order:	34486
Description: 206 Saddle, Outboard, Left side				Part Number:	D2932-1
Inspection Dwg: D2932 Rev. C				Page 1 of 1	

Inspect dimensions highlighted on inspection sheet drawing D2932 Rev. C and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.100	0.140		.125	.125	.125	.125		
B	0.100	0.140		.117	.125	.125	.125		
C	0.100	0.140		.120	.126	.125	.125		
D	0.210	0.230		.219	.222	.222	.226		
E	1.245	1.255		1.250	1.250	1.245	1.245		
F	1.245	1.255		1.250	1.250	1.249	1.245		
G	2.495	2.505		2.500	2.501	2.499	2.499		
H	0.510	0.515		.510	.515	.510	.510		
I	1.572	1.582		1.577	1.577	1.577	1.577		
J	2.495	2.505		2.500	2.500	2.500	2.500		
K	0.257	0.262		.259	.257	.257	.257		
L	0.312	0.317		.313	.314	.314	.314		
M	0.235	0.240		.238	.238	.239	.239		
N	0.100	0.140		.120	.120	.120	.120		
O	0.540	0.560		.552	.550	.550	.550		
P	0.490	0.510		.505	.504	.501	.501		
Q	3.715	3.725		3.720	3.718	3.718	3.718		
R	2.470	2.510		2.500	2.497	2.497	2.497		
S	0.240	0.270		.252	.256	.250	.256		
T	0.100	0.180		.140	.140	.138	.143		
U	1.625	1.635		1.630	1.630	1.630	1.630		
V	1.362	1.372		1.367	1.368	1.368	1.368		
W	0.316	0.321		.319	.319	.319	.315		
X	1.125	1.145		1.136	1.132	1.132	1.132		
Y	1.565	1.585		1.570	1.567	1.567	1.567		
Z	0.178	0.198		.188	.188	.188	.184		
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by:	BF	/ Q.F	Audited by:	JL
Date:	07.09.18	/ 07/09/19	Date:	07/09/20

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690	KJ/RF	
C	07.03.21	Revised per drawing revision C	KJ/JLM	JLM

DART AEROSPACE LTD			Work Order:	34486
Description: 206 Saddle, Outboard, Left side			Part Number:	D2932-1
Inspection Dwg: D2932 Rev. C			Page 1 of 1	

Inspect dimensions highlighted on inspection sheet drawing D2932 Rev. C and record below:

Dim.	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				5	6	7	8		
A	0.100	0.140		.125	.124	.125	.125		
B	0.100	0.140		.125	.124	.125	.125		
C	0.100	0.140		.125	.125	.125	.125		
D	0.210	0.230		.228	.228	.228	.228		
E	1.245	1.255		1.250	1.250	1.250	1.250		
F	1.245	1.255		1.250	1.250	1.250	1.250		
G	2.495	2.505		2.500	2.500	2.500	2.500		
H	0.510	0.515		.510	.510	.510	.510		
I	1.572	1.582		1.577	1.577	1.577	1.577		
J	2.495	2.505		2.500	2.499	2.500	2.500		
K	0.257	0.262		.257	.258	.258	.258		
L	0.312	0.317		.314	.314	.314	.314		
M	0.235	0.240		.238	.238	.238	.238		
N	0.100	0.140		.125	.125	.125	.125		
O	0.540	0.560		.550	.550	.550	.550		
P	0.490	0.510		.500	.500	.500	.500		
Q	3.715	3.725		3.718	3.718	3.718	3.718		
R	2.470	2.510		2.501	2.501	2.501	2.501		
S	0.240	0.270		.250	.261	.260	.260		
T	0.100	0.180		.140	.147	.147	.147		
U	1.625	1.635		1.631	1.631	1.631	1.631		
V	1.362	1.372		1.370	1.370	1.370	1.370		
W	0.316	0.321		.320	.320	.320	.320		
X	1.125	1.145		1.133	1.133	1.133	1.133		
Y	1.565	1.585		1.575	1.575	1.574	1.574		
Z	0.178	0.198		.184	.184	.184	.184		
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									

Accept/Reject

Measured by:	<i>J.F.</i>	Audited by:	<i>J.L.</i>
Date:	<i>07/09/19</i>	Date:	<i>07/09/20</i>

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690	KJ/RF	
C	07.03.21	Revised per drawing revision C	KJ/JLM <i>J.L.</i>	<i>J.L.</i>

34486

DART AEROSPACE LTD		Work Order:	<del>34486</del>
Description: 206 Saddle, Outboard, Left side		Part Number:	D2932-1
Inspection Dwg: D2932 Rev. C		Page 1 of 1	

Inspect dimensions highlighted on inspection sheet drawing D2932 Rev. C and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	9	2	3	4	By	Date
A	0.100	0.140		.125					
B	0.100	0.140		.120					
C	0.100	0.140		.130					
D	0.210	0.230		.228					
E	1.245	1.255		1.250					
F	1.245	1.255		1.250					
G	2.495	2.505		2.500					
H	0.510	0.515		.500					
I	1.572	1.582		1.577					
J	2.495	2.505		2.500					
K	0.257	0.262		.250					
L	0.312	0.317		.313					
M	0.235	0.240		.238					
N	0.100	0.140		.125					
O	0.540	0.560		.550					
P	0.490	0.510		.507					
Q	3.715	3.725		3.720					
R	2.470	2.510		2.500					
S	0.240	0.270		.260					
T	0.100	0.180		.140					
U	1.625	1.635		1.630					
V	1.362	1.372		1.370					
W	0.316	0.321		.318					
X	1.125	1.145		1.132					
Y	1.565	1.585		1.568					
Z	0.178	0.198		.188					
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									

Accept/Reject

Measured by:	<i>S.P</i>	Audited by:	<i>J.L</i>
Date:	<i>07/09/19</i>	Date:	<i>07/09/20</i>

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690	KJ/RF	
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